

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016135**Date Inspected:** 11-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC TESTING

OBG SEGMENT 9CE

ABF Request No: 08112010-1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the weld between side panel and edge of OBG segment 9CE on bike path side. The Inspection was carried out on repair areas only. The weld designations were as follows:

CA064-001 (OBG 9CE, S.P to E.P, BK side)

OBG SEGMENT 9BW-9CW

ABF Report No: UT-9W-062

WELDING INSPECTION REPORT

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This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the weld between bottom panel and side panel on cross beam side of OBG segment 9BW and 9CW. The weld designations were as follows:

SEG051A-021 (OBG 9BW, S.P to B.P, CB side)
SEG053A-014 (OBG 9CW, S.P to B.P, CB side)

This QA Inspector randomly observed the following work in progress.

OBG LIFT 9 WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067665 performing Shielded Metal Arc Welding process for weld 013 located on PCMK DP673-001. ZPMC QC Mr. Shi Lei was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-4114-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067572 performing Shielded Metal Arc Welding process for weld 08 located on PCMK DP687-001. ZPMC QC Mr. Shi Lei was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-4114-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045280 performing Flux Cored Arc Welding process for weld 043 located on PCMK SEG051B. ZPMC QC Mr. Shi Lei was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-3G (3F)-Repair-1. Weld repair report identified as B-WR14516.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045196 performing Shielded Metal Arc Welding process for weld 020 located on PCMK DP685-001. ZPMC QC Mr. Zhou Peng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-485-SMAW-3G (3F)-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
